

Work Order ID 51429

August 24, 2009 11:46:33 AM



Page 1

Item ID: D2056

Accept



Setup Start



Revision ID: B2

Stop



Item Name: Bell Crank

Start Date: 25/08/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 20.00



Customer:

Reference:

20/09/08/24

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2056

Rev B2

100

0.00



BAND SAW

0.00

*memo 09/08/25*200

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks 2.80" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

201

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per folio D2056

Tumble

Deburr

M.A 09/08/25

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

201

QC

Memo

Quality Control

M.A 09/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2056 PAR #: _____ Fault Category: Procl. Machined parts NCR: Yes No DQA: [Signature] Date: 09.09.01
Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 09.09.01

NCR: 51429		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/08/25	110	1 part scrap because of the .191" hole is crooked Locating pin was worn out & loose. F.C. Jig not updated (worn out)	<u>[Signature]</u> 09/08/25	Jig has been changed and updated 09/08/25 Scrap and replace qty 1 M110001	H. A 09/08/25	<u>[Signature]</u> 09/08/26	<u>[Signature]</u> 09/08/26	<u>[Signature]</u> 09/08/26

NOTE: Date & initial all entries

Work Order ID 51429

August 24, 2009 11:46:33 AM



Page 2

Item ID: D2056	Accept		Setup	Start	
Revision ID: B2				Stop	
Item Name: Bell Crank					
Start Date: 25/08/2009	Start Qty: 20.00		Cust Item ID:		
Required Date: 28/08/2009	Req'd Qty: 20.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC. Quality Control	Memo	0.00	amt 09/08/26			20	0		
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00	MD 09/08/27			(20)			
150 	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat Powder Coating	Memo START TIME: 9:00am OVEN TEMPERATURE: 320°F FINISH TIME: 9:30am	0.00	7 9/ 09/08/27			x20	0		

DART AEROSPACE LTD		Work Order:	57429
Description: Bell Crank		Part Number:	D2056
Inspection Dwg: D2056 Rev: B2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	0.751	✓			
0.900	+/-0.010	0.900	✓			
1.000	+/-0.010	1.001	✓			
0.125	+/-0.010	0.126	✓			
0.060	+/-0.010	0.061	✓			
Ø0.191	+0.005/-0.001	Ø0.193	✓			
0.362	+/-0.010	0.362	✓			
0.750	+/-0.010	0.751	✓			
0.385	+/-0.010	0.385	✓			
Ø0.257	+0.006/-0.001	Ø0.259	✓			
0.100	+/-0.010	0.101	✓			
0.300	+/-0.010	0.300	✓			
0.946	+/-0.010	0.946	✓			
0.750	+/-0.010	0.751	✓			
0.075	+/-0.010	0.075	✓			
2.637	+/-0.010	2.638	✓			
0.375	+/-0.010	0.375	✓			
Ø0.513-0.518	0.513 - 0.518	Ø0.517	✓			
R0.450	+/-0.010	R0.450	✓			
R0.125	+/-0.010	R0.125	✓			
R0.200	+/-0.010	R0.200	✓			
R0.550	+/-0.010	R0.550	✓			
R0.263	+/-0.010	R0.263	✓			

Measured by:	L.A	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	09/08/25	Date:	09/08/26	Date:	N/A

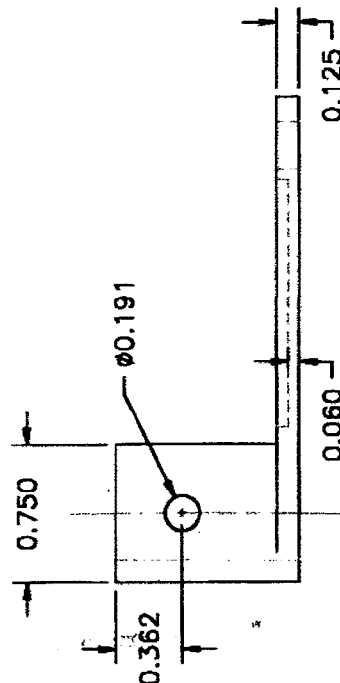
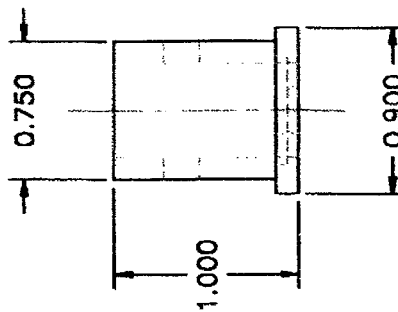
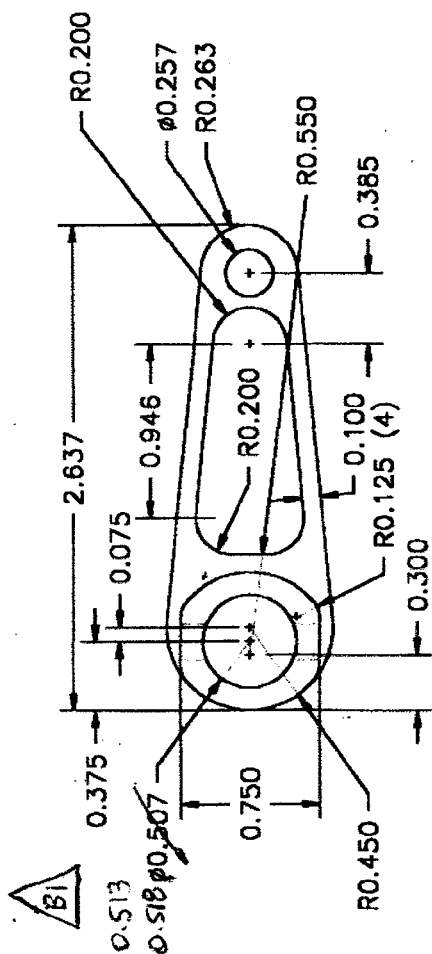
Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

DART



RELEASED
99.04.29 KE

DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>KE</i>	DRAWING NO. D2056	REV. B SHEET 1 OF 1
DATE 92:03:13		TITLE BELL CRANK	SCALE 1:1
B	95:11:02	RE-DESIGN	
B1	<i>IP</i> 01.06.04	MODIFY HOLE SIZE, ADD PIC OPTION	
B2	<i>IP</i> 01.12.20	ADD NOTE ON TOLERANCES	



5/15

ACID ETCH & ANODIZE PER
DART QST 005 4.1
POWDER COAT BLACK SHIMMER
(4.3.5.7) PER DART
QST 005 4.3

MATERIAL: 6061-T6 (QQ-A-225/B)
FINISH: ANODIZE (BLACK) OR

TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISE NOTED.